

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82657

April-04-12 11:08:40 AM

82657

Page 2

Item ID: D2940-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support
 Start Date: 04/04/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 15/05/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFXtube Hand Finishing Crosstubes	Memo Per note 8 on page 1 of dwg D2940, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.	0.00 0.00				<u>20</u>			<u>12/04/20</u>
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<u>Scotch</u>		<u>20</u>			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>LG 52</u> Memo	0.00 0.00				<u>20</u>		<u>12-4-21</u>	<u>20</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82657***82657***

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April-04-12 11:08:40 AM

Item ID: D2940-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 04/04/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/4/23
#7204-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 11:08:45 AM

Page 1

Work Order ID: 82657

82657

Parent Item: D2940-1

D2940-1

Parent Item Name: Support

Start Date: 04/04/2012

Required Date: 15/05/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP C 02.11.26 Reformat; Added P/OKJ

IPP Rev:D Added priming as per Rev B 07-04-30 JLM

IPP E 08.03.19 Re-format Ec verified by DD

IPP Rev:F 08-10-22 add qc14 DD verified by:EC

IPP Rev:G

11.08.04 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK081		Manufactured	No			110	Each	14.0000	0.5	10.52632			

DSK081

**

D2940-1 TURNING DETAIL

Location

Loc Qty

Loc Code

MAT060

14

69717

4

79879

10

10

FK 12/04/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82657
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.160	.160	.160	.160	.160
AD	3.510	3.530		3.519	3.518	3.517	3.517	3.520
AE	1.633	1.673	✓	1.657	1.658	1.658	1.658	1.658
AF	1.493	1.513	✓	1.499	1.508	1.507	1.507	1.507
AG	0.040	0.060		.050	.049	.052	.049	.051
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.156	.157	.157	.157	.158
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.150	.155	.155	.155	.155
AN	0.350	0.450		.380	.380	.380	.380	.380
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.152	.153	.153	.153	.151
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by:	FK	Date:	12/04/14
Audited by:	CMX	Date:	12/04/14
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

DART AEROSPACE LTD		Work Order:	82657
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940		Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6X	7X	8X	9X	10X
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.160	.160	.160	.160	.160
AD	3.510	3.530		3.520	3.520	3.520	3.517	3.517
AE	1.633	1.673		1.660	1.657	1.660	1.659	1.659
AF	1.493	1.513		1.508	1.507	1.511	1.509	1.507
AG	0.040	0.060		.050	.049	.052	.048	.050
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.157	.156	.157	.158	.158
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.155	.154	.155	.155	.155
AN	0.350	0.450		.380	.380	.380	.380	.380
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.151	.150	.150	.150	.152
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: F.K.	Date: 12/04/15
Audited by: [Signature]	Date: 12/04/19
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	[Signature]

DART AEROSPACE LTD		Work Order:	82657
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.160	.160	.160	.160	.160
AD	3.510	3.530		3.516	3.516	3.516	3.516	3.515
AE	1.633	1.673		1.659	1.658	1.658	1.659	1.658
AF	1.493	1.513		1.506	1.506	1.508	1.507	1.507
AG	0.040	0.060		.052	.050	.051	.050	.049
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.158	.158	.158	.158	.157
AJ	2.518	2.538		2.528	2.528	2.529	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.155	.155	.155	.155	.155
AN	0.350	0.450		.380	.380	.380	.380	.380
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170	.153	.153	.152	.150	.152	.151
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: E.K.	Date: 12/04/16
Audited by: <i>cmf</i>	Date: 12/04/19
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
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DART AEROSPACE LTD		Work Order:	82657
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

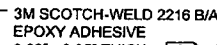
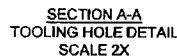
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	0.250
AB	0.490	0.510		.500	.500	.500	.500	0.500
AC	0.140	0.160		.160	.160	.160	.160	0.160
AD	3.510	3.530		3.517	3.517	3.516	3.516	3.516
AE	1.633	1.673		1.660	1.657	1.658	1.663	1.659
AF	1.493	1.513		1.510	1.503	1.509	1.510	1.510
AG	0.040	0.060		.051	.047	.051	0.049	0.049
AH	0.188	0.193		.188	.188	.188	0.188	0.188
AI	0.140	0.160		.157	.158	.158	0.155	0.157
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	0.050	0.049
AL	0.010	0.020		.010	.010	.010	0.010	0.010
AM	0.140	0.160		.155	.155	.155	0.155	0.157
AN	0.350	0.450		.380	.380	.380	0.380	0.380
AO	0.240	0.260		.250	.250	.250	0.250	0.250
AP	0.150	0.170		.150	.154	.149	0.153	0.150
AQ	0.053	0.073		.063	.063	.063	0.063	0.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	0.260	0.260
AT	0.053	0.073		.063	.063	.063	0.063	0.063
AU	4.118	4.138		4.128	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by:	FK. / B	Date:	12/04/16
Audited by:	[Signature]	Date:	12/04/19
Prototype Approval:		Date:	






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B	07.05.08	Dwg Rev. updated	KJ/JLM	
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E	12.01.31	Dwg Rev. updated	KJ	[Signature]



NO. 82657 MLC
12/04/04



- ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE PER NCR 642, PRIME INSIDE	PH	07.03.13
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA DRAWING NO. D2940 REV. 1 SHEET 1 OF 1 TITLE Ø3.250 SUPPORT NT DATE 11.07.15	
DRAWN			
CHECKED	AS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE		COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR CONVEYANCE TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	